



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10333-041
Job Sheet 190316



Part No: RB 92700-10333-041

Job Qty: 2 pcs

Part Name: Engine Shaft Puller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RB 92700-10333-041 Rev.A IPP Rev. A 18.06.06 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	3/15/19		0.00	2.00	Small Fab - 1		AP 2019/02/27
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 4	2 pcs	3/15/19		0.00	0.00	QC 4 - 26		Mickel
							QC 4 - 28		
							QC 4 - 42		
							QC 4 - 58		
							QC 4 - 6		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
130	Packaging 3-1 - Stock - B4B	2 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S155131



Part: RB 92700-10333-041

Job No: 190316

Serial No/Batch: S155131

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 02/20/19

Plex 2/7/19 8:57 AM Dart.Macdonald.Dara

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

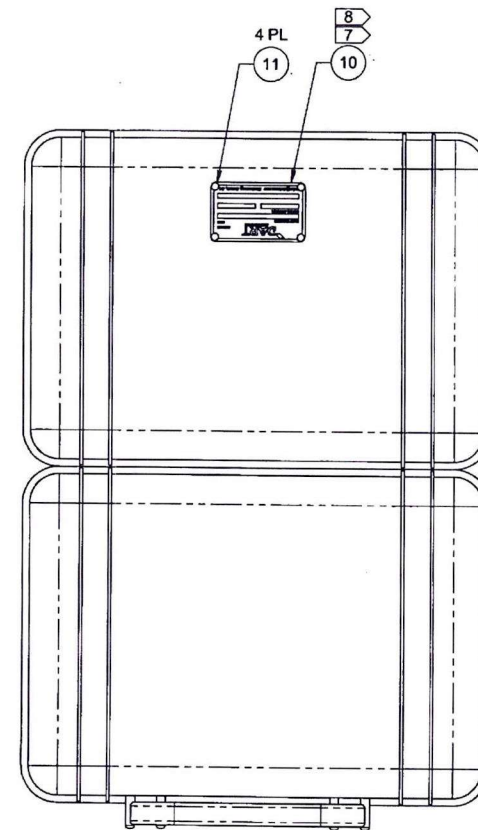
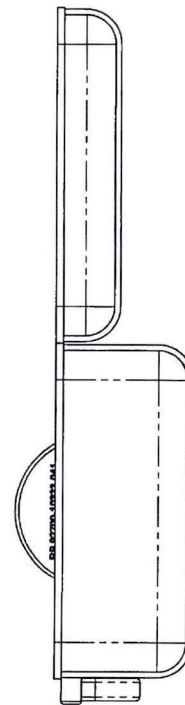
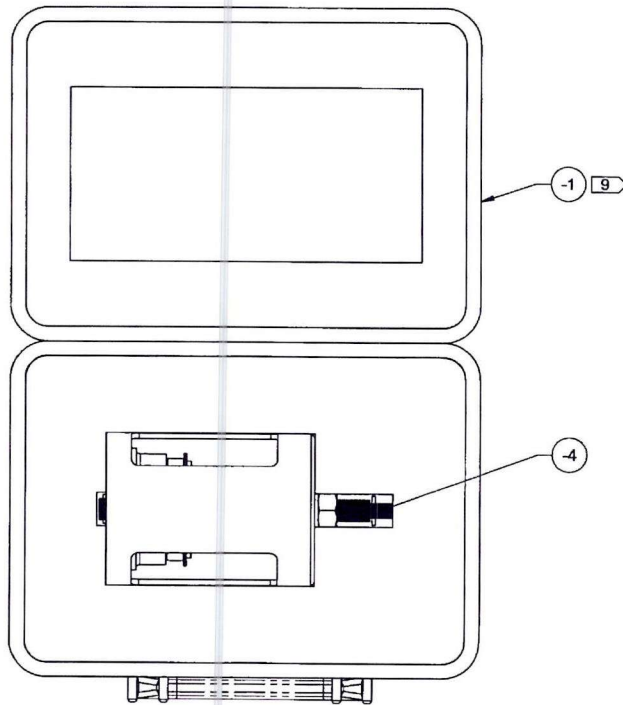
Part Op 110 - Small Fab 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican
 Descriptions: case APP-1450-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case
 and pack case as per DWG.
 120 - QC4- 100% Inspect kits for completeness
 130 - Identify as per dwg & Stock Location:
 140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	110-Small Fab - 1	5145165
RB 92700-10333-041-2	Top Foam use in case APP-1450-E	2 Ea (1 ea)	110-Small Fab - 1	5130781
RB 92700-10333-041-3	Bottom Foam use in case APP-1450-E	2 Ea (1 ea)	110-Small Fab - 1	5130780
RB 92700-10333-041-4	Engine Drive Shaft Removal Tool Assy	2 pcs (1 ea)	110-Small Fab - 1	5139864
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	110-Small Fab - 1	5621040
APP-1450-E	Pelican case	2		5130779

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	8	526	0
	RB 92700-10333-041-2	2	2	0
	RB 92700-10333-041-3	2	2	0
	RB 92700-10333-041-4	2	0	0
	RB41011	2	423	0

Part Specifications	
Specifications could not be found.	

ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10333-041-1	PACKAGING ASSY
-4	1	RB 92700-10333-041-4	ENGINE DRIVE SHAFT REMOVAL TOOL ASSY
10	1	RB41011	DART PLACARD
11	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



RB 92700-10333-041 ENGINE DRIVE SHAFT REMOVAL TOOL

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

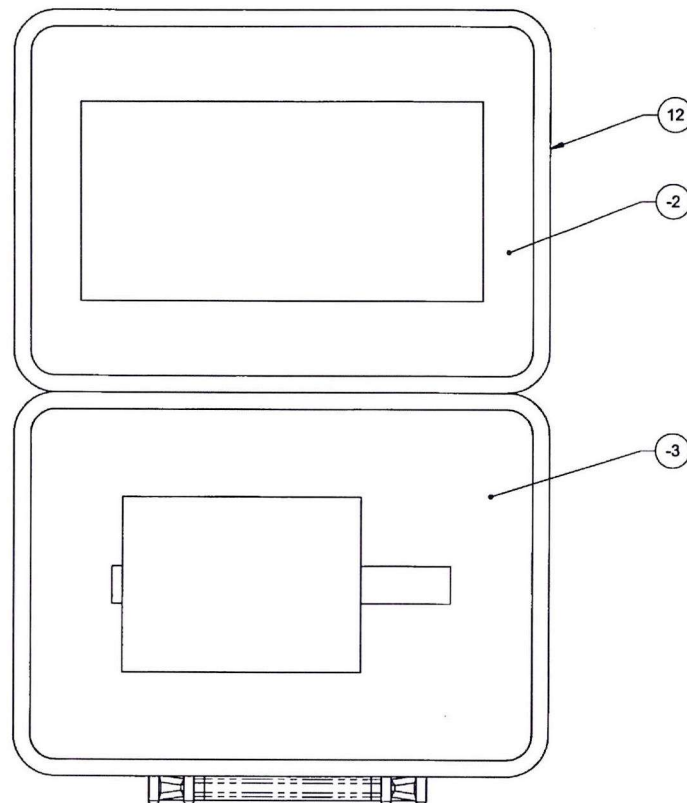
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE	18-639	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA TOOL PART # RB 92700-10333-041 TITLE ENGINE DRIVE SHAFT REMOVAL TOOL SCALE NTS COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	VM		
CHECKED	<i>VM</i>		
MFG. APPR.	DP		
APPROVED	<i>VM</i>		
DATE	5/29/2018		

ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10333-041-2	TOP FOAM
-3	1	RB 92700-10333-041-3	BOTTOM FOAM
12	1	PELICAN #APP-1450-E	PELICAN CASE 1450



RB 92700-10333-041-1 PACKAGING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

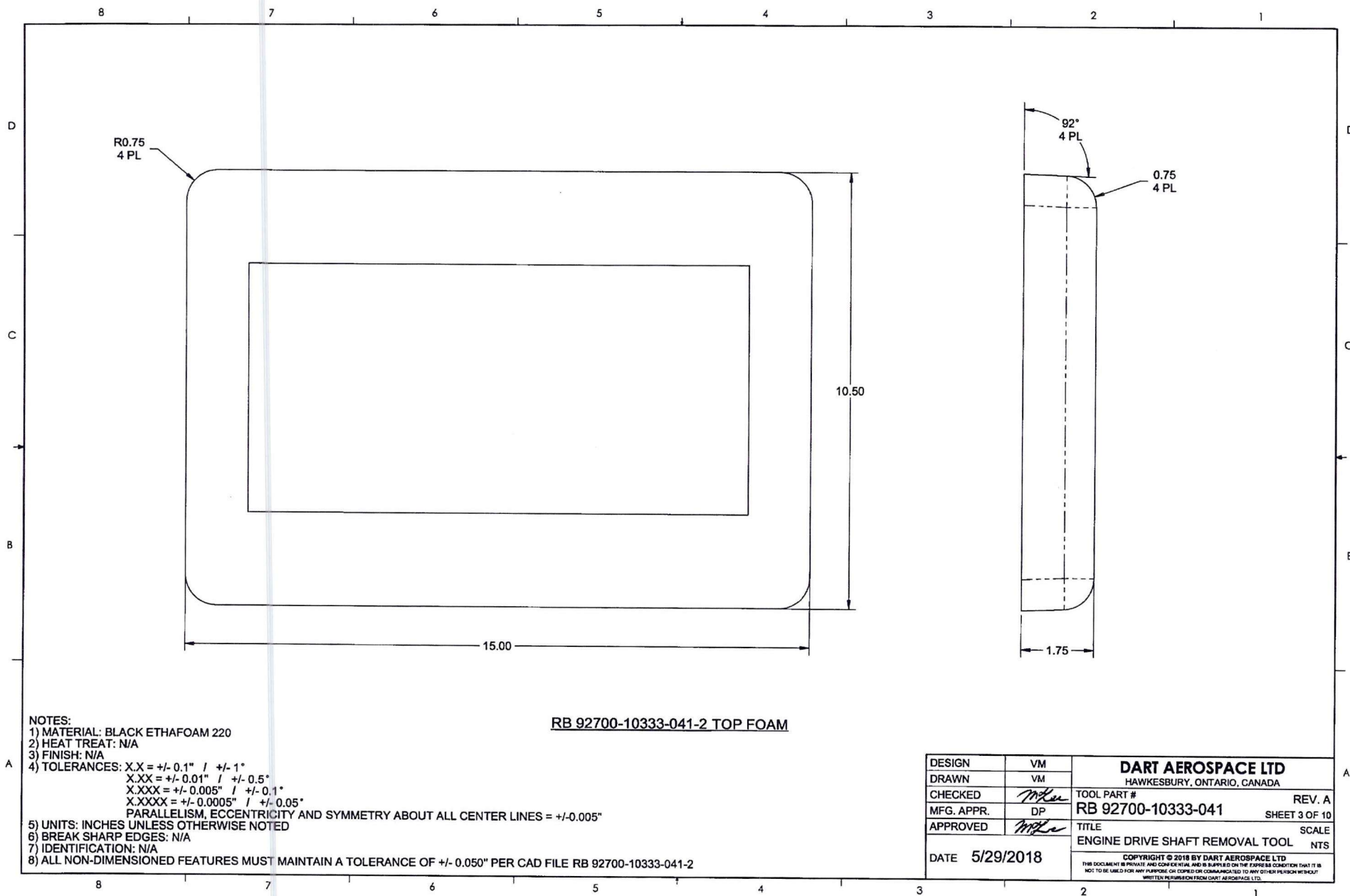
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

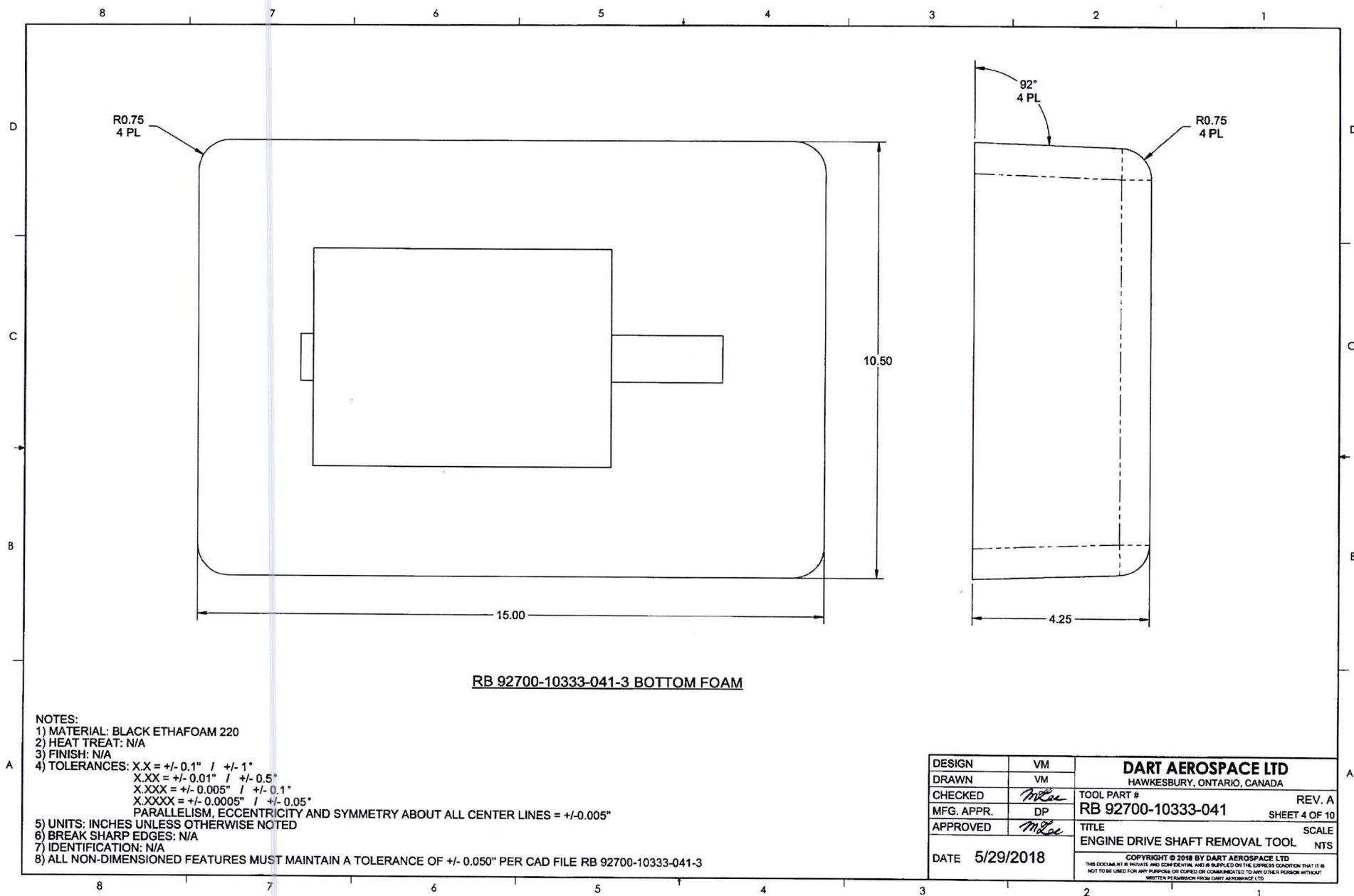
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

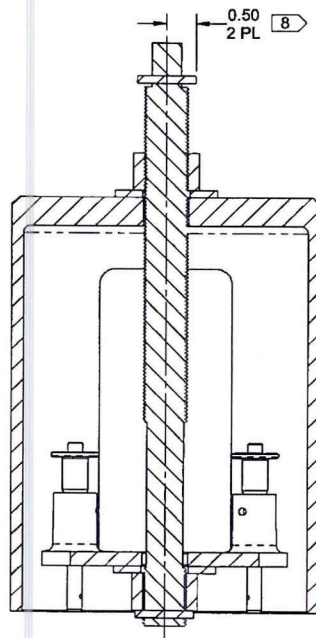
7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10333-041	SHEET 2 OF 10
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 5/29/2018		ENGINE DRIVE SHAFT REMOVAL TOOL	NTS
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ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10333-041-5	REACTOR
-6	1	RB 92700-10333-041-6	SHAFT
-7	1	RB 92700-10333-041-7	REMOVAL ASSY
13	2	McMaster#91845A175 OR EQUIV	SS HEX NUT 3/4"-16
14	2	McMaster#92141A056 OR EQUIV	SS FLAT WASHER 3/4"
15	2	McMaster#98380A475 OR EQUIV	SS DOWEL PIN 1/8" DIA. x 1" LG.



RB 92700-10333-041-4 ENGINE DRIVE SHAFT REMOVAL TOOL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

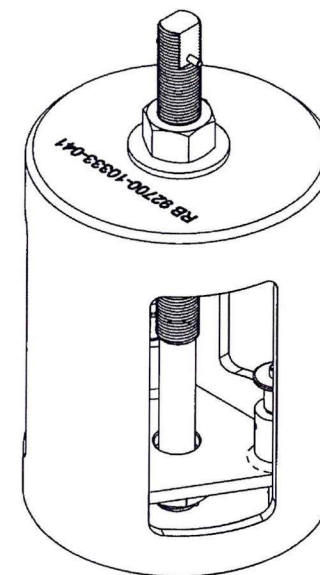
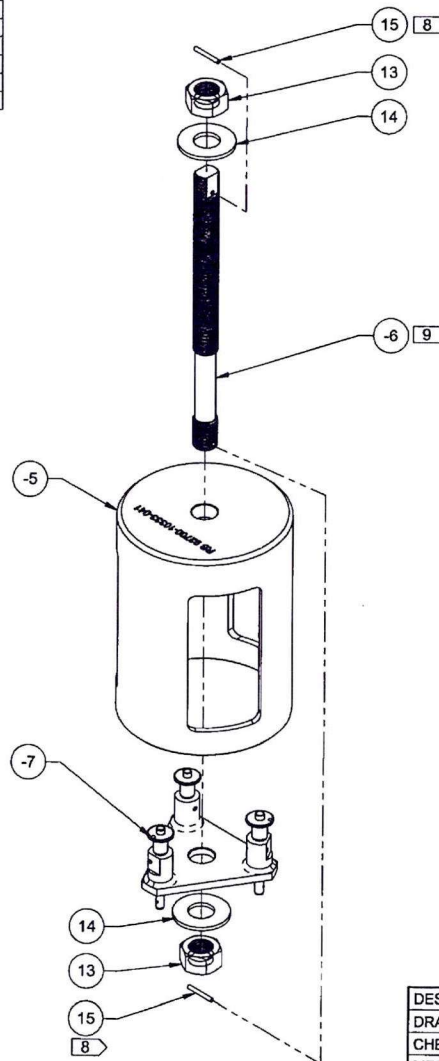
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

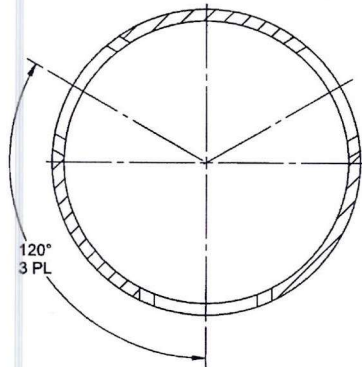
7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN, APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 15 CENTERED WITH ITEM -6 AS SHOWN AND REMOVE EXCESS

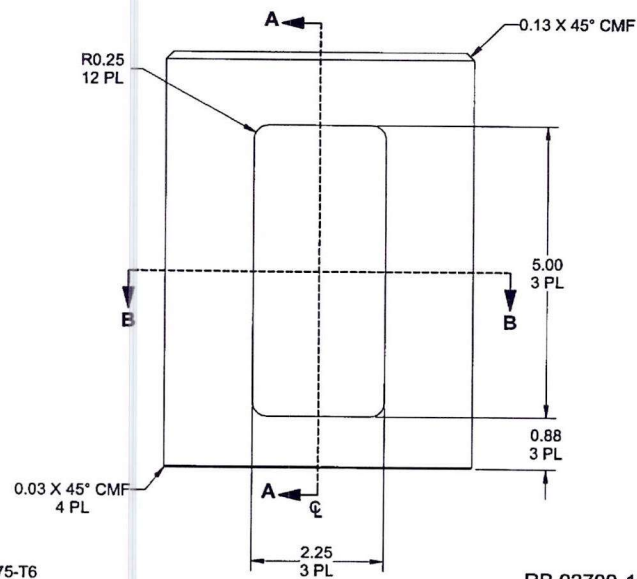
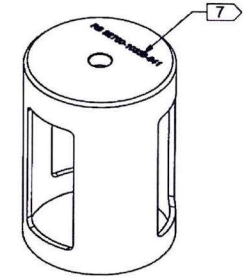
9) APPLY A SMALL AMOUNT OF LOCTITE NICKEL BASED ANTI SEIZE ON THREADS OF ITEM -6



DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MKen</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10333-041	SHEET 5 OF 10
APPROVED	<i>MKen</i>	TITLE	SCALE
		ENGINE DRIVE SHAFT REMOVAL TOOL	NTS
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SECTION B-B



SECTION A-A

RB 92700-10333-041-5 REACTOR

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
- X.XX = +/- 0.01" / +/- 0.5"
- X.XXX = +/- 0.005" / +/- 0.1"
- X.XXXX = +/- 0.0005" / +/- 0.05"
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MZae</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10333-041	SHEET 6 OF 10
APPROVED	<i>MZae</i>	TITLE	SCALE
		ENGINE DRIVE SHAFT REMOVAL TOOL	NTS
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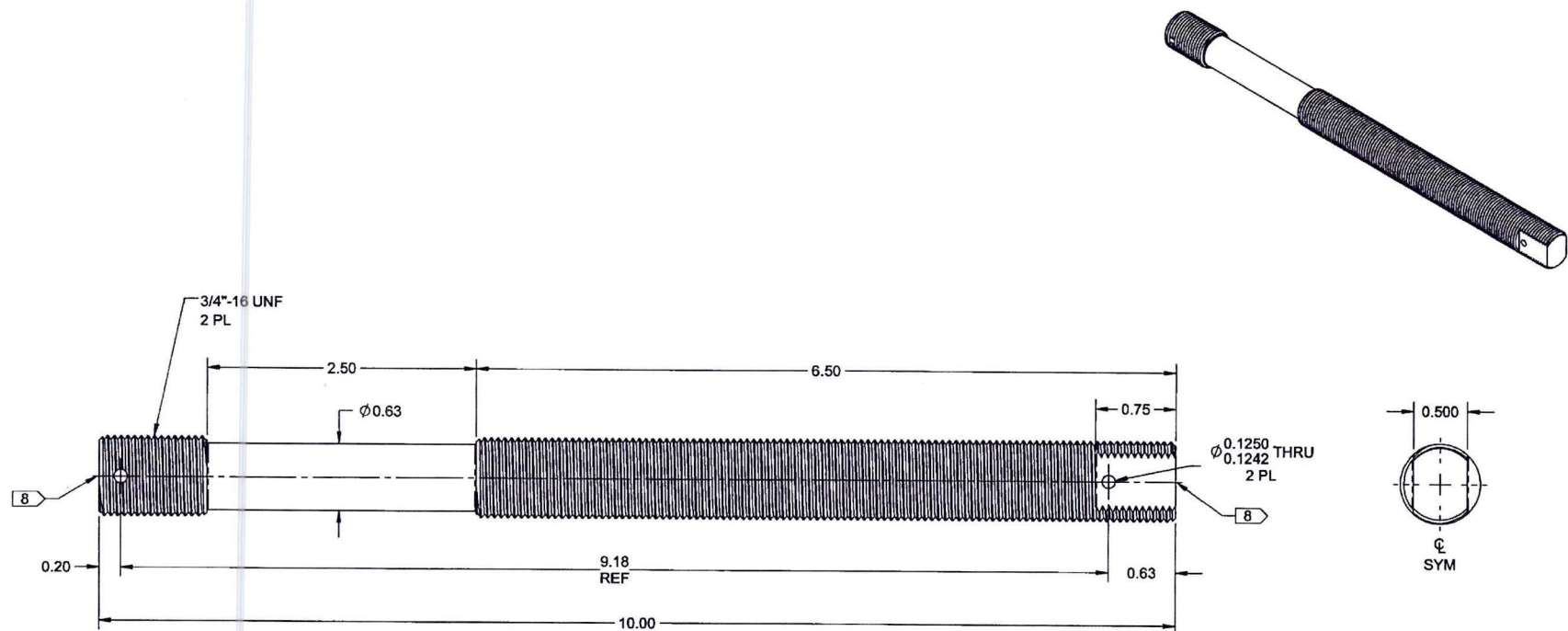
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RB 92700-10333-041-6 SHAFT

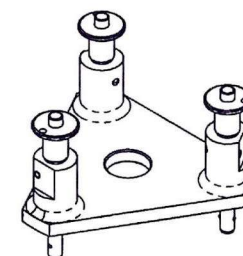
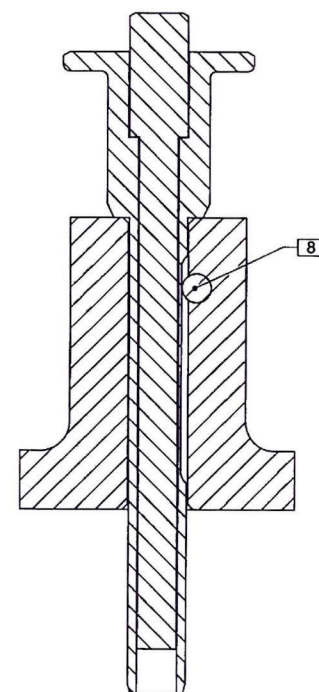
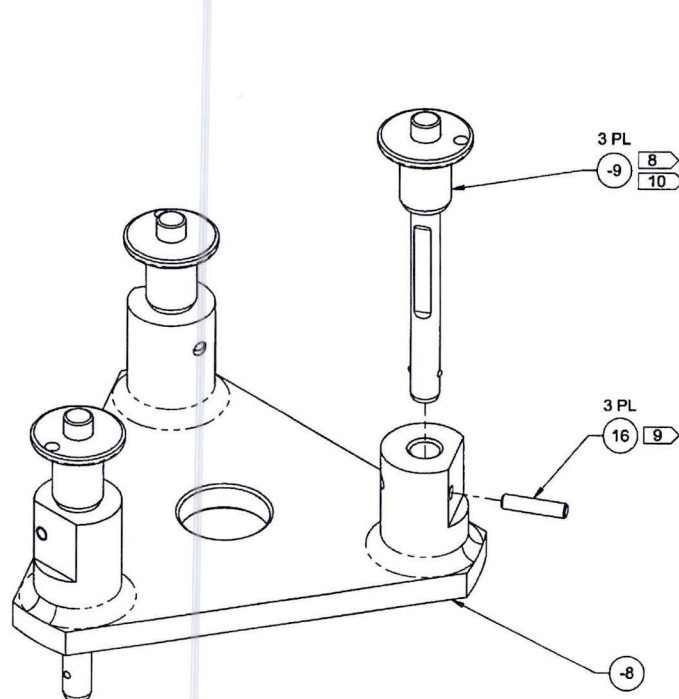
NOTES:

- 1) MATERIAL: 17-4PH-H900 STAINLESS STEEL
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10333-041	SHEET 7 OF 10
APPROVED	<i>ML</i>	TITLE	SCALE
		ENGINE DRIVE SHAFT REMOVAL TOOL	NTS
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ITEM #	QTY	PART #	PART TITLE
-8	1	RB 92700-10333-041-8	REMOVAL PLATE
-9	3	RB 92700-10333-041-9	QUICK RELEASE PIN MODIFIED
16	3	McMaster#98380A901 OR EQUIV	SS DOWEL PIN 1/8" DIA. x 9/16" LG.

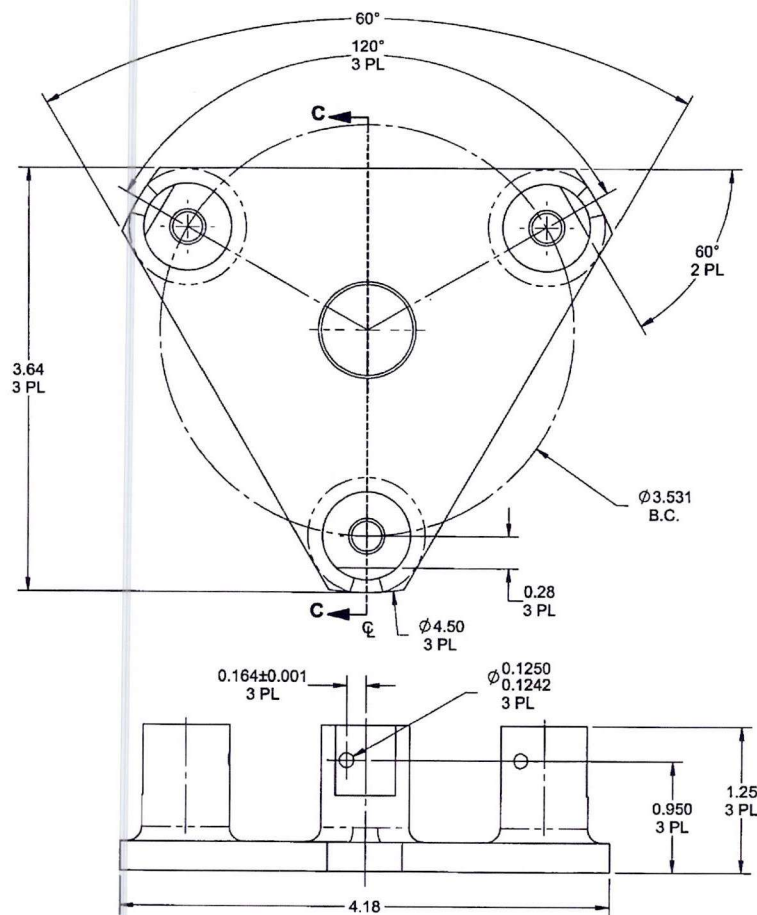


RB 92700-10333-041-7 REMOVAL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN, ALIGN GROOVE OF ITEM -9 WITH ITEM 16 AS SHOWN
- 9) PRESS FIT ITEMS 16 WITH ITEMS -8
- 10) ITEMS -9 MUST MOVE FREELY

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	<i>M. Lee</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10333-041	SHEET 8 OF 10
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 5/29/2018		ENGINE DRIVE SHAFT REMOVAL TOOL	NTS
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RB 92700-10333-041-8 REMOVAL PLATE

NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: N/A

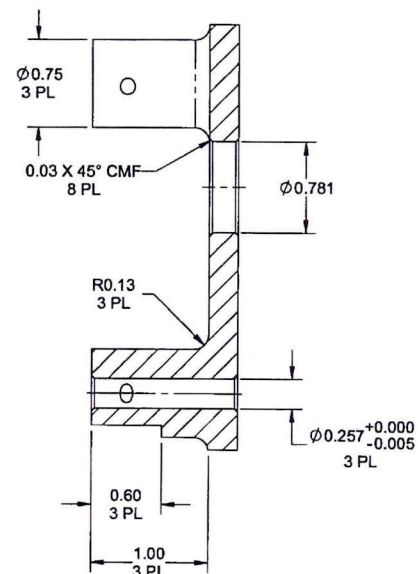
4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RB 92700-10333-041-8



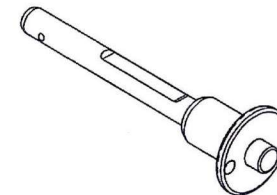
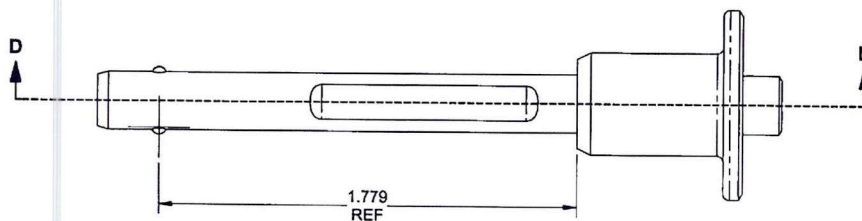
SECTION C-C

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	<i>Miles</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10333-041	SHEET 9 OF 10
APPROVED	<i>Miles</i>	TITLE	SCALE
DATE	5/29/2018	ENGINE DRIVE SHAFT REMOVAL TOOL	NTS
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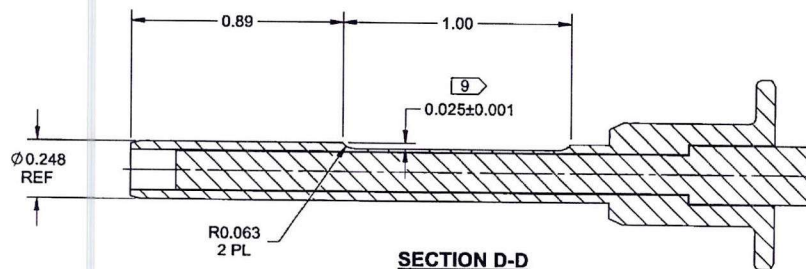
D

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C

C



SECTION D-D

8

RB 92700-10333-041-9 QUICK RELEASE PIN MODIFIED

NOTES:

- 1) MATERIAL: McMaster#90985A129 OR EQUIV
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A
- 8) REMOVE LANYARD AND RING IF APPLICABLE
- 9) FLAT MUST NOT BREAK THROUGH PIN WALL

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ML</i>	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10333-041	SHEET 10 OF 10
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 5/29/2018		ENGINE DRIVE SHAFT REMOVAL TOOL	NTS
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8 7 6 5 4 3 2 1

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					